

dec 19, MA



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

D5953

Job Sheet 168495



Part No: D5953

Job Qty: 4 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/15/17

Job Tracking No:

Due Date: 12/4/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:f ecn 826 06.12.06 EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off     |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |              |
| 90    | Start up Operation     | 4 Ea  |            | 12/1/17  | 0.00      | 0.00    | Start Up Machining    |           | FR 17-12-12  |
| 100   | CNC Vertical Machining | 4 pcs |            | 12/2/17  | 0.79      | 10.53   | HAAS 1                |           | SBL 17/12/14 |
| 110   | QC                     | 4 pcs |            | 12/2/17  | 0.00      | 0.00    | QC1                   |           | SBL 17/12/14 |
| 120   | QC                     | 4 pcs |            | 12/2/17  | 0.00      | 0.00    | QC8                   |           | 17-12-16     |
| 130   | HandFinish             | 4 pcs |            | 12/2/17  | 0.00      | 0.37    | HandFinish1           |           | BEB 17/12/15 |
| 140   | Powdercoat             | 4 pcs |            | 12/4/17  | 0.00      | 0.19    | Powdercoat1           |           | BR 17-12-19  |
| 150   | QC                     | 4 pcs |            | 12/4/17  | 0.00      | 0.00    | QC3                   |           | 17-12-19     |
| 160   | Packaging              | 4 pcs |            | 12/4/17  | 0.00      | 0.00    | Packaging3            |           | AT           |
| 170   | QC21-SA                | 4 Ea  |            | 12/4/17  | 0.00      | 0.00    | QC21                  |           | AT           |

Part Op 100 - 1-Machine as per folio D5953, Ensure Batch Number is entered

Descriptions: 110 - Inspect on CMM as per folio CMM017.

140 - START TIME: 8:20 O.V.T. 300° FINISH: 8:50 -

M 138467.

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D6101-007      | 4        | 28        | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 11/15/17 3:03 PM dart.poulin.mario





|                                      |               |                     |        |
|--------------------------------------|---------------|---------------------|--------|
| <b>DART AEROSPACE LTD</b>            |               | <b>Work Order:</b>  | 168495 |
| <b>Description: Inner Fwd Saddle</b> |               | <b>Part Number:</b> | D5953  |
| <b>Inspection Dwg: D5953</b>         | <b>Rev: B</b> | <b>Page 1 of 1</b>  |        |

Inspect dimensions highlighted on inspection sheet drawing and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4     |    |      |
| A             | 0.438 | 0.443 |                | .438                       | .438  | .438  | .438  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 5.245 | 5.255 |                | 5.250                      | 5.250 | 5.250 | 5.250 |    |      |
| D             | 6.995 | 7.005 |                | 7.000                      | 7.000 | 7.000 | 7.000 |    |      |
| E             | 5.240 | 5.260 |                | 5.250                      | 5.250 | 5.250 | 5.250 |    |      |
| F             | 4.745 | 4.755 |                | 4.750                      | 4.750 | 4.750 | 4.750 |    |      |
| G             | 0.315 | 0.322 |                | .316                       | .316  | .316  | .316  |    |      |
| H             | 1.522 | 1.532 |                | 1.527                      | 1.527 | 1.527 | 1.527 |    |      |
| I             | 3.048 | 3.058 |                | 3.053                      | 3.053 | 3.053 | 3.053 |    |      |
| J             | 4.575 | 4.585 |                | 4.580                      | 4.580 | 4.580 | 4.580 |    |      |
| K             | 0.315 | 0.322 |                | .316                       | .316  | .316  | .316  |    |      |
| L             | 0.495 | 0.505 |                | .500                       | .500  | .500  | .500  |    |      |
| M             | 0.490 | 0.510 |                | .501                       | .502  | .502  | .501  |    |      |
| N             | 1.615 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |    |      |
| O             | 7.990 | 8.010 |                | 8.000                      | 8.000 | 7.999 | 8.000 |    |      |
| P             | 2.240 | 2.260 |                | 2.250                      | 2.250 | 2.250 | 2.250 |    |      |
| Q             | 0.307 | 0.312 |                | .310                       | .310  | .309  | .310  |    |      |
| R             | 0.760 | 0.765 |                | .762                       | .762  | .762  | .762  |    |      |
| S             | 0.490 | 0.510 |                | .499                       | .499  | .500  | .500  |    |      |
| T             | 1.375 | 1.395 |                | 1.380                      | 1.380 | 1.380 | 1.380 |    |      |
| U             | 2.000 | 2.020 |                | 2.005                      | 2.005 | 2.005 | 2.005 |    |      |
| V             |       |       |                |                            |       |       |       |    |      |
| W             |       |       |                |                            |       |       |       |    |      |
| X             |       |       |                |                            |       |       |       |    |      |
| Y             |       |       |                |                            |       |       |       |    |      |
| Z             |       |       |                |                            |       |       |       |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

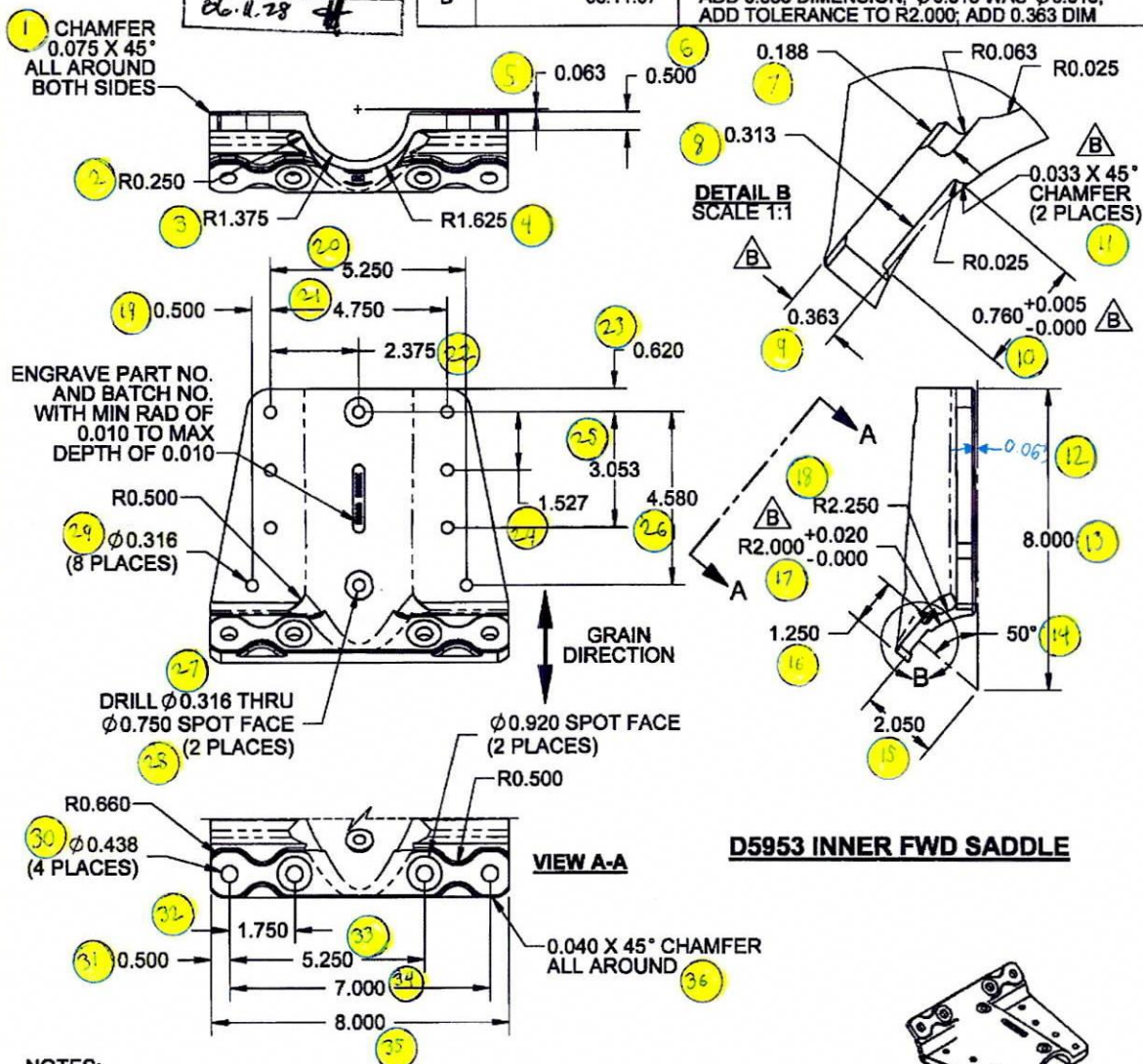
|                     |
|---------------------|
| Measured by: SBL /m |
| Date:               |

|                                  |
|----------------------------------|
| Audited by: 17/12/14 A. 17-12-16 |
| Date:                            |

| Rev | Date     | Change                                                 | Revised by | Approved |
|-----|----------|--------------------------------------------------------|------------|----------|
| A   | 99.04.19 | New Issue                                              | RF         |          |
| B   | 02.12.13 | Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B | KJ/RF      |          |
| C   | 06.12.06 | Dimensions L,N,P revised                               | KJ/EC      |          |
| D   | 07.06.15 | Dimension G revised                                    | KJ/JLM     |          |
| E   | 08.04.21 | Dimension E revised                                    | KJ/DD      |          |
| F   | 08.12.01 | Dimension K revised                                    | KJ/DD      |          |

**DART**

|                         |                                  |                                                                                                                                   |                        |
|-------------------------|----------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|------------------------|
| DESIGN<br><b>BW</b>     | DRAWN BY<br><b>CB</b>            | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                          |                        |
| CHECKED<br><b>LE</b>    | APPROVED<br><b>#</b>             | DRAWING NO.<br><b>D5953</b>                                                                                                       | REV. B<br>SHEET 1 OF 1 |
| DATE<br><b>06.11.07</b> | TITLE<br><b>INNER FWD SADDLE</b> |                                                                                                                                   | SCALE<br>1:4           |
| REV<br><b>A</b>         | DATE<br><b>97.05.06</b>          | DESCRIPTION<br><b>NEW ISSUE</b>                                                                                                   |                        |
| <b>B</b>                | <b>06.11.07</b>                  | INCORPORATE DEO 9102, DEO 9079;<br>ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ;<br>ADD TOLERANCE TO R2.000; ADD 0.363 DIM |                        |

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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